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## FORMULATION FOR CORROSION AND SCALE INHIBITION

The present invention relates to a method of preventing or alleviating the problems associated with metal sulphide deposits and to novel formulations for use in such a method.

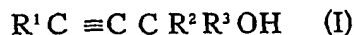
Tetrakis (hydroxyorgano) phosphonium salts (hereinafter THP<sup>+</sup> salts), especially tetrakis (hydroxymethyl) phosphonium sulphate (hereinafter THPS) are widely used as metal sulphide dissolver/dispersers within aqueous systems and especially those systems associated with oilfields.

When THPS is used in oilfields, it is typically applied in concentrations of up to 30%, together with an ammonium salt to improve performance. This combination of THPS and an ammonium salt, together with high temperatures that can be experienced in oilfield applications, can be corrosive to mild steel and other metal components.

It is an aim of the present invention to ameliorate the above problems of corrosion by THP<sup>+</sup> salts when used in aqueous systems.

Accordingly, the present invention, in a first aspect, provides a formulation for use in the treatment of corrosion and metal sulphide scale deposits in aqueous systems, said formulation comprising a THP<sup>+</sup> salt (as hereinbefore defined), and a primary, secondary or tertiary alcohol having an acetylenic bond in the carbon backbone.

Preferably, the acetylenic bond is adjacent to the hydroxyl group, said alcohol having the general formula (I):



wherein:

$R^1$ ,  $R^2$  and  $R^3$  (which may be the same or different) each independently represent hydrogen,  $C_1$  to  $C_8$  alkyl or functionally substituted alkyl.

In a particularly preferred embodiment of the present invention, the alcohol is propargyl alcohol (2-propyn-1-ol), i.e. in formula (I),  $R^1$ ,  $R^2$  and  $R^3$  are each hydrogen.

The metal sulphide scale may be iron sulphide. Alternatively, the metal sulphide may be lead sulphide or zinc sulphide or a combination thereof. The iron sulphide may be Troilite ( $FeS$ ) or Pyrite ( $FeS_2$ ). Alternatively, the iron sulphide may be Mackinawite ( $Fe_9S_8$ ) or Pyrrhotite ( $Fe_7S_8$ ).

The anion of the  $THP^+$  salt should be compatible with the aqueous system. Preferred anions include sulphate, chloride, phosphate, bromide, fluoride, carbonate, citrate, lactate, tartrate, borate, silicate, formate and acetate. The anion should make the  $THP^+$  salt water-soluble.

The formulation may further include a surfactant. The surfactant is preferably a cationic surfactant, for example quaternary ammonium compounds, N-alkylated heterocyclic compounds or quaternised amidoamines. Alternatively, anionic, amphoteric or non-ionic surfactants may be used. Aminomethane phosphonates may replace ammonium salts in the aqueous system.

The formulation according to the invention is particularly useful in the prevention of corrosion of mild steel, copper and aluminium.

The present invention also provides, in a second aspect, a method for treatment of an aqueous system containing or in contact with a metal sulphide scale while concomitantly inhibiting the corrosion of surfaces in

contact with said aqueous system, which method comprises the addition to said aqueous system of a scale and corrosion inhibiting amount of a formulation in accordance with the first aspect of the invention.

The aqueous system is preferably one used in enhanced oil recovery. Alternatively, the aqueous system may be one used in industrial water systems, paper manufacturing systems and any aqueous system wherein corrosion caused by  $\text{THP}^+$  salts occurs.

The present invention also provides, in a third aspect, a formulation consisting essentially of the reaction product of a  $\text{THP}^+$  salt and an acetylenic alcohol in accordance with the first aspect of the present invention, wherein the ratio of said  $\text{THP}^+$  salt to said acetylenic alcohol is between 1:1 and 750:1.

The formulation as described in the first aspect is preferably used in an effective amount up to 30% by weight as  $\text{THP}^+$ . The amount used will vary by application but it may also be effectively used for low level applications e.g. 1 to 10000ppm as a  $\text{THP}^+$  salt or in high level applications as 1 to 30% as a  $\text{THP}^+$  salt. In the second aspect  $\text{THP}^+$  is preferably used in an effective amount of up to 30% by weight as a  $\text{THP}^+$  salt, with the co-addition of an acetylenic alcohol in an effective amount of between 0.1 to 10000 ppm, relative to the volume of the system being treated.

The ratio of  $\text{THP}^+$  to the acetylenic alcohol in the formulation is typically in the range 1:1 to 750:1, more preferentially 15:1 to 300:1, most preferably about 40:1.

The present invention will be illustrated, merely by way of example, as follows.

**Example 1.**

**Blank Experiment:** A 100ml solution of 20% THPS (26.6g TOLCIDE® PS75) and 1g ammonium chloride in synthetic seawater was placed in a 120ml screw-top jar. A pre-weighed mild steel coupon was immersed in the solution. The jar was then stored in a 50°C oven for 48 hours. After this time the coupon was cleaned by gentle scrubbing in water, washed with acetone and dried in the oven. The coupons were then reweighed and the corrosion rate calculated according to the equation:

$$\text{Rate} = \frac{K \times W}{A \times T \times d}$$

W = Weight loss in g (to 0.1mg)

A = Area in Cm<sup>2</sup> (to 0.01 cm<sup>2</sup>)

T = Time of exposure in hours

d = Density in g/cm<sup>3</sup>

K is a constant defined by the units in which the corrosion rate is required. For example:

<u>Units</u>	<u>K</u>
Mpy - mils per year	$3.45 \times 10^6$

This experiment was repeated with various levels of corrosion inhibitor added to the blank solution. The results are shown in Table A below:

TABLE A

Experiment	Corrosion Rate mpy
Blank	208
Blank + 5000ppm Inhibitor A	77
Blank + 5000ppm Inhibitor B	197
Blank + 5000ppm Inhibitor C	116
Blank + 5000ppm Inhibitor D	132
Blank + 5000ppm Inhibitor E	88
Blank + 5000ppm Inhibitor F	86
Blank + 5000ppm propargyl alcohol	33

**Blank** - A solution consisting of 20% THPS and 1% ammonium chloride in synthetic seawater.

**Inhibitor A** - Commercially available corrosion inhibitor comprising ethoxylated ammonium chloride, dibutyl thiourea and ethoxylated fatty acid.

**Inhibitor B** - Commercially available corrosion inhibitor comprising polyoxyethylene 2-ethylhexyl ether phosphate.

**Inhibitor C** - Oilfield corrosion inhibitor comprising fatty acids and Tall oil reaction products with diethylene triamine.

**Inhibitor D** - Commercially available corrosion inhibitor comprising a phosphonocarboxylic acid.

**Inhibitor E** - Standard commercially available oilfield corrosion inhibitor based on an amine alkoxylate.

**Inhibitor F** - Standard commercially available oilfield corrosion inhibitor comprising an amine ethoxylate and a quaternary ammonium chloride.